

slip April 10

Work Order ID 115548

April-04-14 7:26:59 AM

115548

Page 1

Item ID: D5076-3

Revision ID:

Item Name: Bracket

Start Date: 4/04/14

Start Qty: 8.00

8

Required Date: 4/21/14

Req'd Qty: 8.00

8

Reference:

Accept

N900040100

Setup

Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MLD

Date: 14-04-07

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D5076

A

100

100

Waterjet

FLOW CNC Waterjet

6061.040

FLOW WATER JET

Memo

1- Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2- Deburr

0.00

0.00

8

0

Jm14-04-5

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

8

0

Jm14-04-5

April-04-14 7:26:59 AM

115548

Page 2

8

g

N900040100

Setup Start *NS1*

Stop *NS2*

Customer:

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____

Run Start *NR1*

Stop *NR2*

0.00

DAS
27
9-89

14/4.

14/04/09

Work Order ID 115548

April-04-14 7:26:59 AM

115548

Page 3

Item ID: D5076-3

Revision ID:

Item Name: Bracket

Start Date: 4/04/14

Start Qty: 8.00

8

Required Date: 4/21/14

Req'd Qty: 8.00

8

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per OSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

DAS
30
9-89

170

Identify as per dwg & Stock Location: CA

0.00

170

Packaging

Memo

0.00

Packaging

DAS
30
9-89

Work Order ID 115548

April-04-14 7:26:59 AM

115548

Page 4

Item ID: D5076-3

Revision ID:

Item Name: Bracket

Start Date: 4/04/14 Start Qty: 8.00

Required Date: 4/21/14 Req'd Qty: 8.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

180

180

QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

MLJ 14-04-14

① 14-4-11

Picklist Print

April-04-14 7:27:02 AM

Page 1

Work Order ID: 115548

115548

Parent Item: D5076-3

D5076-3

Parent Item Name: Bracket

Start Date: 4/04/14

Required Date: 4/21/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 14.04.02 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

sf

279.5000

4

M6061T6S 040

**

Jm14-04-5

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

279.5

m126350

48.8

m126981

94.41

m128422

136.29

128422

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

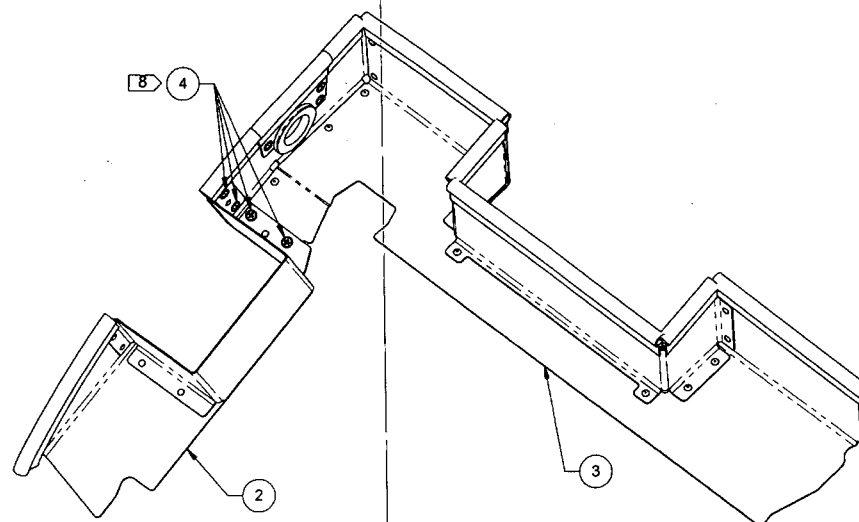
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____

ITEM	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D5076-041	FWD BRACKET ASSEMBLY
2	1	D4434-045	FWD OUTBOARD BRACKET ASSEMBLY
3	1	D5076-043	FWD INBOARD BRACKET ASSEMBLY
4	4	AN525-832R7	SCREW



D5076-041 FWD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.39 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

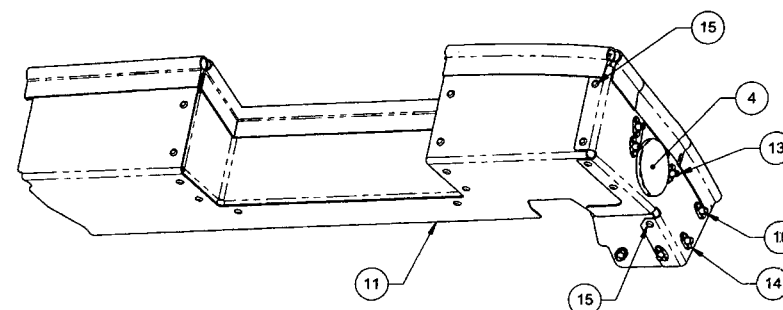
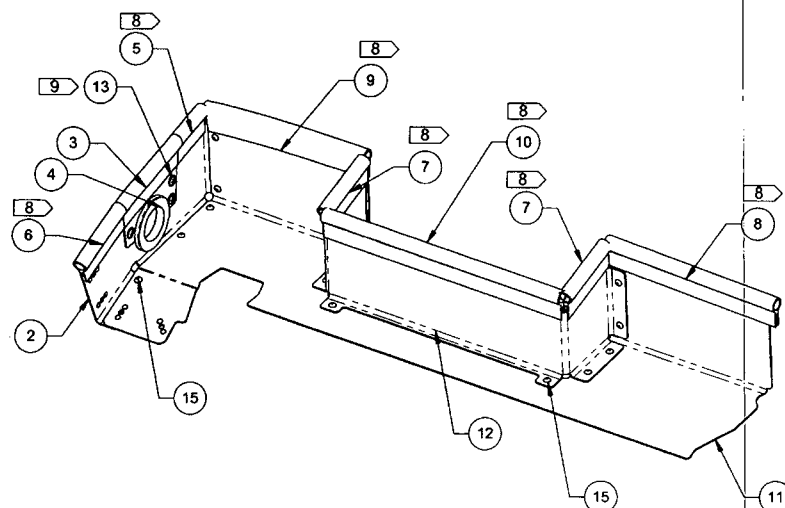
115548 M.C.S
14-04-04

RELEASED
2014-03-31

APPROVED

A	NEW ISSUE	RF	14.03.11
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DD	D5076	SHEET 1 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
DATE	14.03.11	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D5076-043	FWD INBOARD BRACKET ASSEMBLY
2	1	D4434-9	BRACKET
3	1	D4435-041	BRACKET ASSEMBLY
4	1	D4440-1	GROMMET
5	1	D4441-1-017	RUBBER SEAL
6	1	D4441-1-025	RUBBER SEAL
7	2	D4441-1-026	RUBBER SEAL
8	1	D4441-1-067	RUBBER SEAL
9	1	D4441-1-064	RUBBER SEAL
10	1	D4441-1-094	RUBBER SEAL
11	1	D5076-1	BRACKET
12	1	D5076-3	BRACKET
13	3	AN525-832R6	SCREW
14	14	MS20426AD3-3	RIVET
15	15	MS20470AD4-3	RIVET
16	7	MS21075L08	NUT PLATE
17	A/R	3M 1300/1300L	ADHESIVE



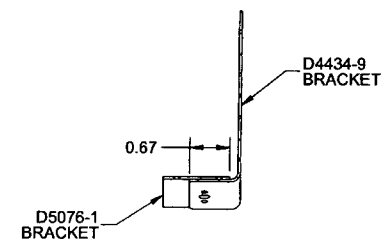
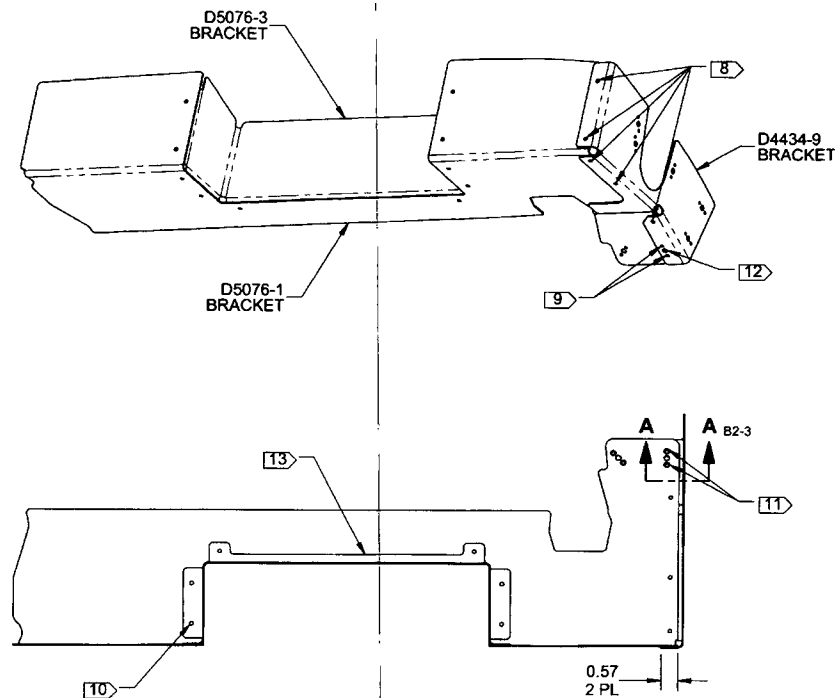
D5076-043 FWD INBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3 PRIOR TO INSTALLING D4435-041.
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.01 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE COVER IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING
- 9) TORQUE SCREW TO 12-15 (in-lb)

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2014-03-31

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	MFG. APPR.	DD	D5076	SHEET 2 OF 7
	APPROVED	HS	TITLE	SCALE
	DE APPR.	D3	BRACKET ASSEMBLY	NTS
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SECTION A-A C4-3

D5076-043 FWD INBOARD BRACKET ASSEMBLY
AUXILIARY VIEW

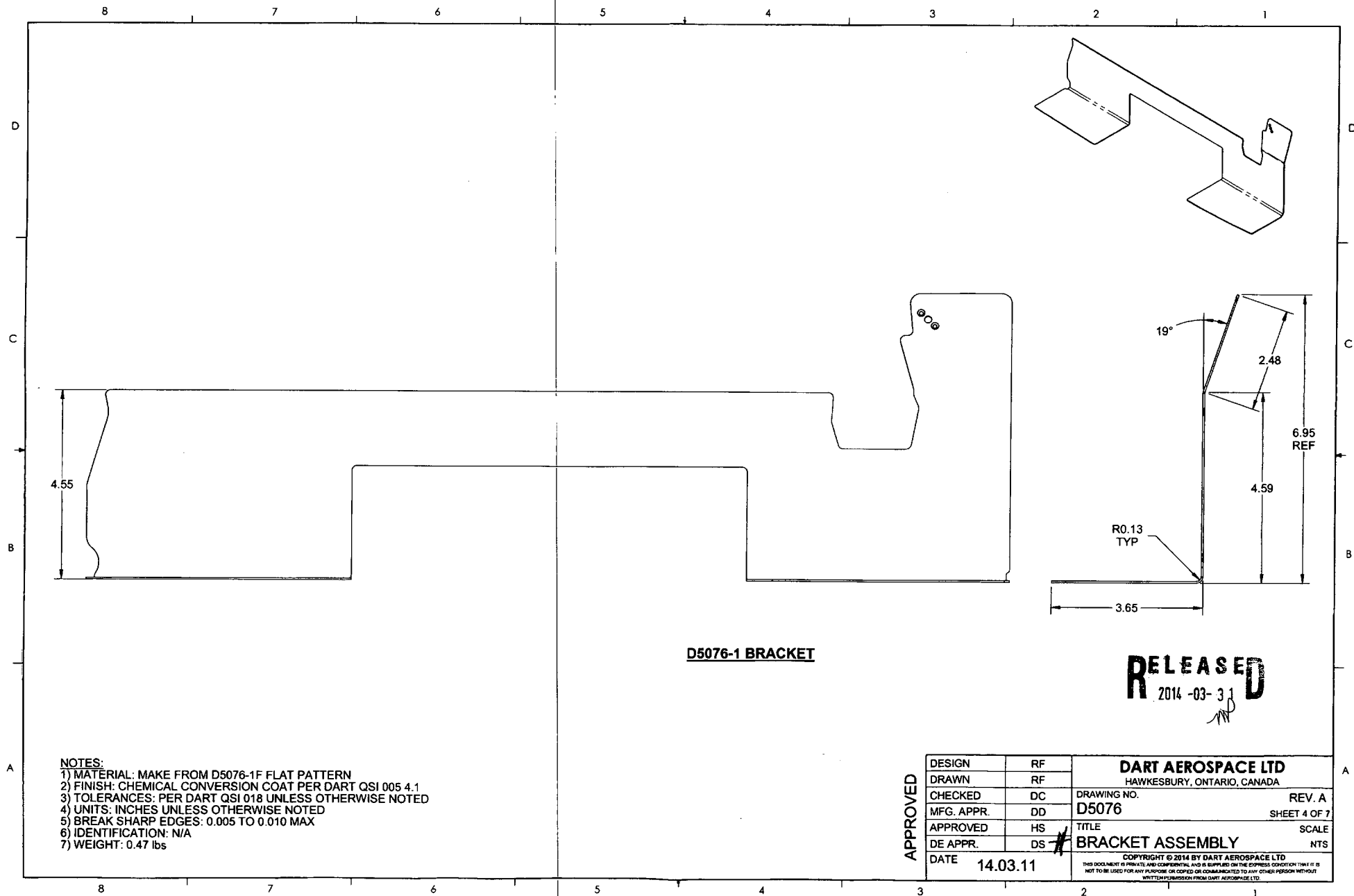
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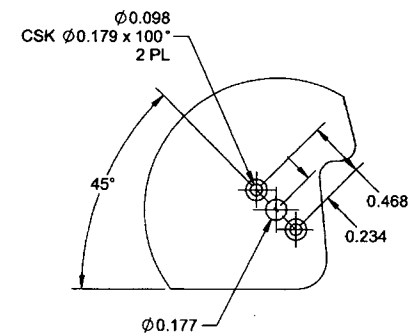
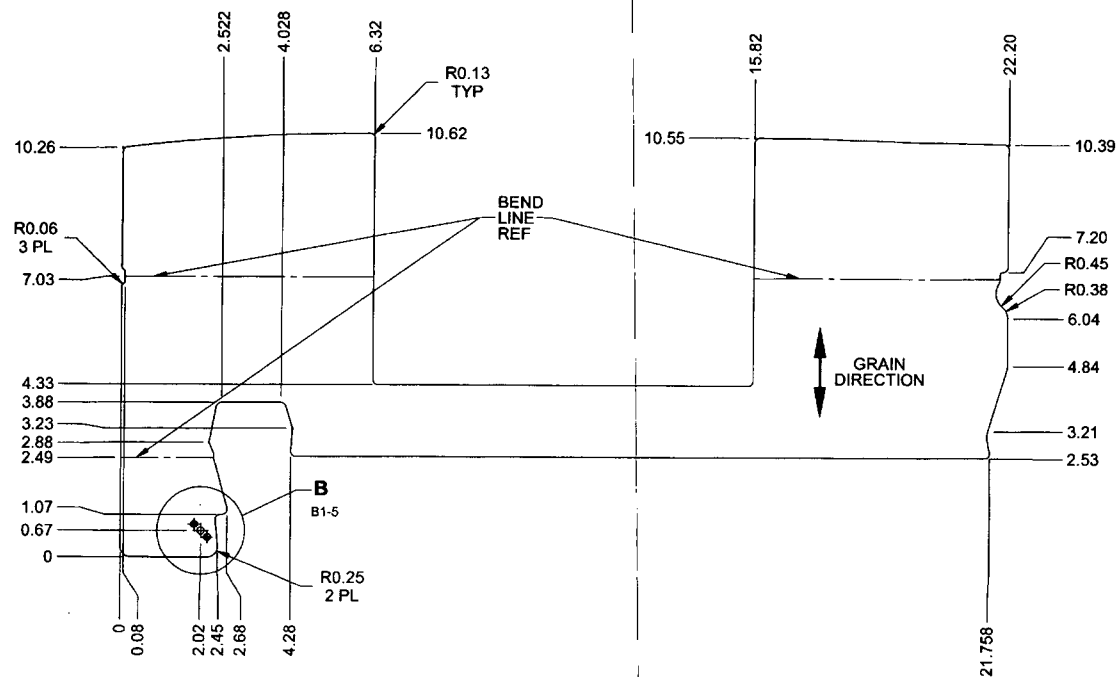
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs
- 8) TRANSFER $\phi 0.129$ HOLES THRU 5 PLACES FROM D4434-9 TO D5076-1
- 9) TRANSFER $\phi 0.098$ HOLES THRU 2 PLACES FROM D4434-9 TO D5076-1
- 10) TRANSFER $\phi 0.129$ HOLES THRU 10 PLACES FROM D5076-3 TO D5076-1
- 11) CSK $\phi 0.179 \times 100^\circ$ ON THIS SIDE 2 PLACES
- 12) TRANSFER $\phi 0.177$ HOLE THRU FROM D4434-9 TO D5076-1
- 13) CENTRE D5076-3 INTO OPENING OF D5076-1

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2014-03-31

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DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DD	D5076	SHEET 3 OF 7
APPROVED	HS	TITLE	SCALE
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DETAIL B B1-5

D5076-1F FLAT PATTERN BRACKET

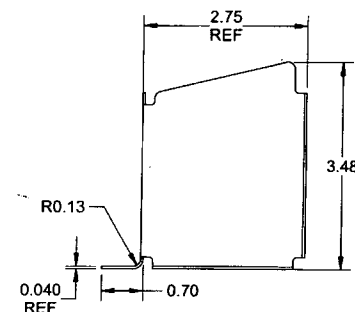
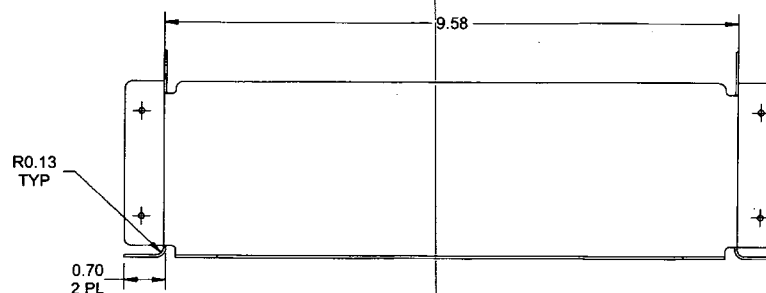
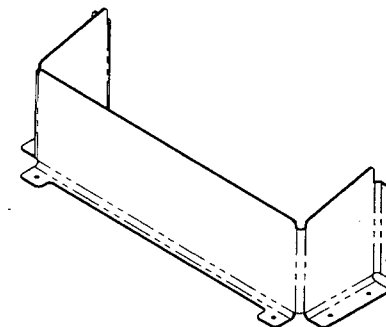
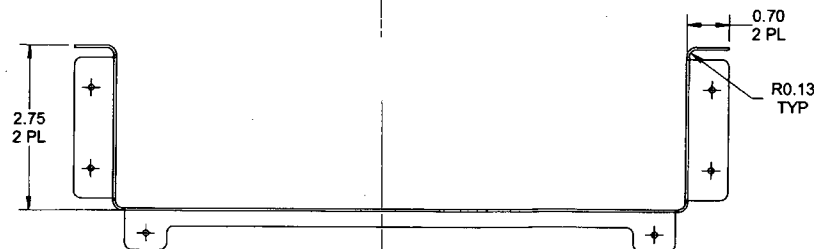
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

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2014-03-31

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DD	D5076	SHEET 5 OF 7
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D5076-3 BRACKET

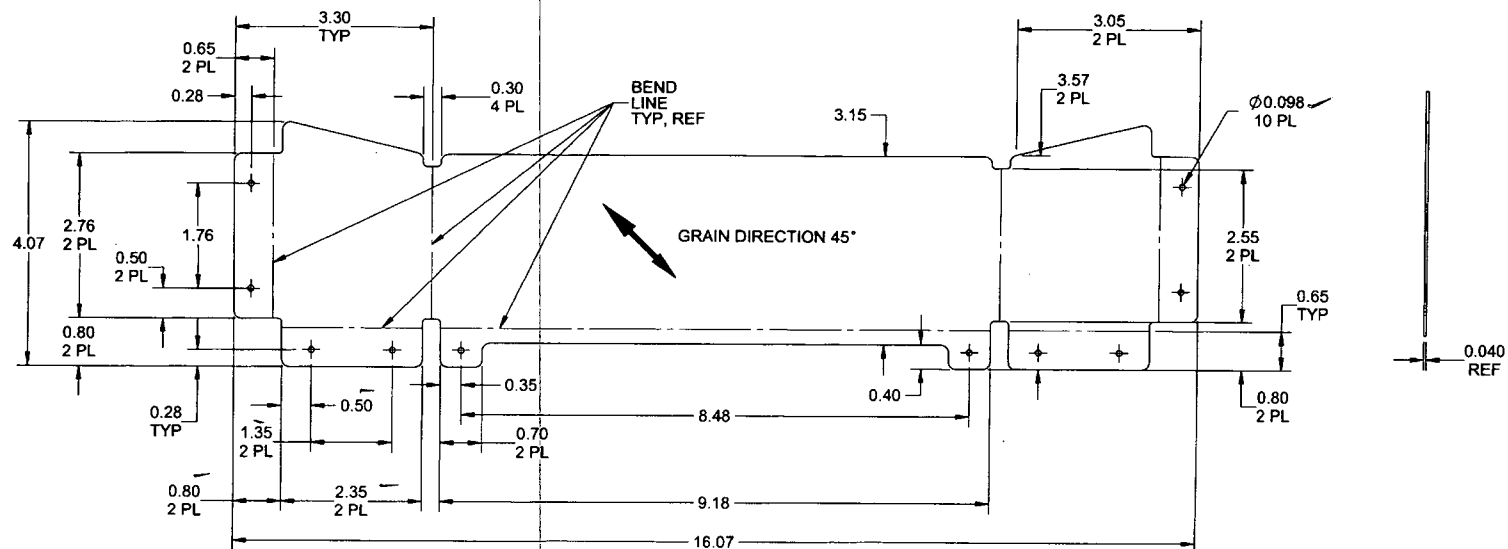
RELEASED
2014 -03- 31

NOTES:

- 1) MATERIAL: MAKE FROM D5076-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.21 lbs

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DD	D5076	SHEET 6 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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D5076-3F FLAT PATTERN BRACKET

RELEASED
2014-03-31

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.21 lbs

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	DD	D5076	SHEET 7 OF 7
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